

## ABSTRACT OF THE DISCLOSURE

The dope prepared from a mixture solvent and solid contents  
5 such as cellulose ester and additives is cast on a drum cooled  
to  $-5^{\circ}\text{C}$  to form a gel-like film. The gel-like film is peeled  
off from the drum. Tension of 60 kg/m is applied to the gel-like  
film in the widthwise direction thereof and the temperature of  
the gel-like film is kept  $120^{\circ}\text{C}$ , when the content of the solvent  
10 to the solid contents in the gel-like film is in a range of 100  
wt.% to 20 wt.%. Further the gel-like film is dried to be a  
cellulose ester film having 40  $\mu\text{m}$  thickness. The IR spectrum  
of the cellulose ester film has a peak in a range of  $520\text{ cm}^{-1}$   
to  $480\text{ cm}^{-1}$  which indicates the crystallization of the polymer.  
15 The cellulose ester film has tear strength of 12g, Rth of 42nm  
and Re of 1.2 nm. As crystallization of the polymer proceeds,  
the cellulose ester film has sufficient strength and optical  
properties.